

Date: Thursday, 11/09/2008 10:41:49 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	CROSSBOLT SPACER		
Job Number	41970			Part Number	D2649		
Estimate Number	11010			Drawing Number	D2649 REV B1		
P.O. Number	:			Project Number	N/A		
This Issue	11/09/2008	S.O. No.	:	Drawing Revision	B1		
Prsh Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	15/10/2008	Qty:	200
Previous Run	41594			Um:	Each		
Written By	:						
Checked & Approved By	DU 08.9.11						
Comment	Est F 02.03.26 Added turning on Cobra NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W	
		Comment: Qty.: 0.2975 f(s)/Unit Total : 59.4930 f(s) 6061-T6 Tube .375 x.058W Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall	Batch M109314
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per folio F214 on cobra machine.	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Banbury</i>	
6.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	
	Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	L11970
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

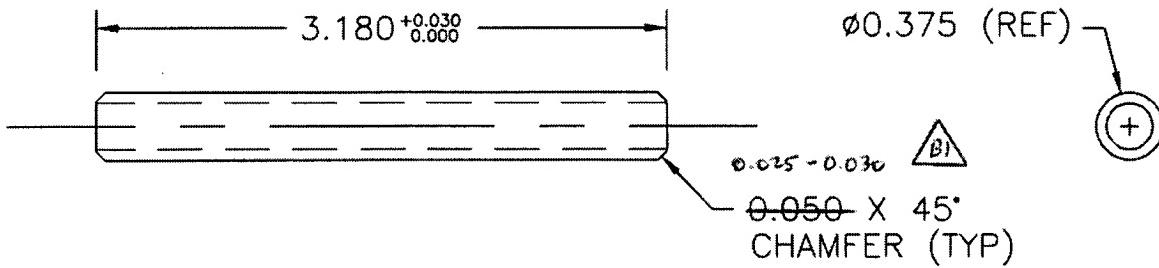
Measured by:	<i>mmt</i>	Audited by:	<i>gj</i>	Prototype Approval:	N/A
Date:	08/09/19	Date:	08/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	[Signature]



DESIGN <i>DW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DW</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
 0.375 DIA 0.058 WALL
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 14970